

over

Work Order ID 149931
Monday, August 15, 2016 7:25:39 AM

149931

Page 1

Item ID: D3391-025

Accept

Revision ID:

Aft Tube Assembly

N9nnn4n1nn

Setup Start

NST

Start Date:	8/15/2016	Start Qty:	1.00
-------------	-----------	------------	------

1

Cust Item ID:

5

Approvals: _____ **Process Plan:** 21

Date: ~~AUG 15 2016~~ Tooling:

Date:

Run

Start

NR1

QC: 9-62

Date: _____ SPC (Y/N): _____

Date:

Run

Start

NR1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	J								

100

MORI SEIKI CNC LATHE LARGE

0.02

Mori Seiki

Memo

0.22

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: _____ & Dwg D3391 Rev: _____

ensure steady test is turning true

*****REMOVE STEADY REST AND MACHINIG MARKS*****

110

QC2- Inspect parts off machine FAI/FAJB

00.0

11U

Memo

00:0

Quality Control

Work Order ID 149931
Monday, August 15, 2016 7:25:39 AM

14.9.9.31

Item ID: D3391-025
Revision ID:
Item Name: Aft Tube Assembly
Start Date: 8/15/2016 Start Qty: 1.00
Required Date: 8/22/2016 Req'd Qty: 1.00
Reference:

1
1

Cust Item ID:
Customer:

Setup Start *NS1*
Stop *NS2*

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112 QC *112* Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							1 38 DAC AUG 19 2016

120
120
HAAS 1
HAAS CNC VERTICAL MACHINING #1
Memo
1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: T
2-Debur

116-10-23

130
QC
1.30
Quality Control
QC2- Inspect parts off machine FA/FAIB
Memo
0.00
0.00

116-10-23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
NCR No. _____		Suspected Unapproved ☐								MRB (QS1042) Approval ☐	
Date : _____		Step # : _____		QTY Effective : _____						Completed By _____	
Description Work Order Deviation				Disposition							
Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐						
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐						
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐						
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Mismatched/off center ☐	Turning Sequence ☐						
Past Expiry Date ☐	Manufacturing Process ☐										
Misidentified ☐	Past Due ☐										
				OTHER : ☐							

Work Order ID 149931
Monday, August 15, 2016 7:25:39 AM

14.9931

Item ID: D3391-025 Accept *N.9000040100* Setup Start *N.S1*
Revision ID: Aft Tube Assembly Stop *N.S2*
Start Date: 8/15/2016 Start Qty: 1.00 Cust Item ID:
Required Date: 8/22/2016 Req'd Qty: 1.00 *1*
Reference: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC	QC5- Inspect part completeness to step on W/O	0.00							
Memo									
Quality Control									

4015

1 0 170878

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Skid-tube Machining ☐ Thermoforming Large Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐		MRB (QSI042) Approval					
Date : _____		Step # : _____		QTY Effective : _____		MRB (QSI042) Approval					
Description Work Order Deviation				Disposition							
Root Cause		FAULT CATEGORY									
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	

Work Order ID 149931
Monday, August 15, 2016 7:25:39 AM

14.9.931

Item ID: D3391-025

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 8/15/2016

Required Date: 8/22/2016

Reference:

Accept

1

Cust Item ID:

1

Customer:

Setup

Start

Stop

NS1

NS2

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Run

Start

Stop

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
1RN	Skidtubes	0.22							

Memo

- 1-Open Aft cap pilot hole to .208" as per Dwg D3391
- 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.
- 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig.
- *****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5- Detail DD, open (5) forward wearplate holes 0.375" then use DT10247 and drill holes for nutplates and c'sink.

6-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX

~~HARTHEST AFT HOLES ONLY***~~

7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

8-Debur

9- Scribe batch # on fwd end

14.9.931

117-08-21

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
NCR No. _____		Suspected Unapproved ☐		QTY Effective : _____						MRB (QS1042) Approval	
Date : 17/9/22		Step #: 180								INSP 12 9 17/9/22	
Description Work Order Deviation				Disposition							
Asst cap holes are at 2° from nominal				Acceptable Cosmetic							
				Completed By INSP 12 9 17/9/22							
				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							

FAULT CATEGORY																			
Root Cause				Pressure/Forced				Temperature/Cure				Power Loss/Surge				Positioned Wrong			
Environment ☐				Bending ☐				Set-up ☐				Folio/Program ☐				Outside Dimensions ☐			
Design ☐				Centre Not Concentric ☐				BOM/Route ☐				Grain ☐				Over/Under tolerance ☐			
Doc/Data ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Part Incorrect ☐			
Equip/Tooling ☐				Crimp/Kink/Ripple/Wave ☐				Inspection Incomplete/Unqualified ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Handling/Pre ☐				Cuffs ☐				Contamination ☐				Out of Sequence ☐				Part Moved ☐			
Material ☐				Crushing ☐				Countersink ☐				Off-set ☐				Drawing ☐			
Internal Transport ☐				Heat Treat ☐				Cut Too Short ☐				Mislabeled ☐				Finish ☐			
Tribal Knowledge ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐				Fit/Function ☐				Misread ☐			
LOA ☐				Marks/Chatter ☐				Drill Holes ☐				Misaligned/off center ☐				Turning Sequence ☐			
Substation ☐																			
Past Expiry Date ☐																			
Misidentified ☐																			
				OTHER : _____															

Work Order ID 149931

149931

Monday, August 15, 2016 7:25:39 AM

Item ID: D3391-025 Accept *NS1* Setup Start Stop *NS2*
Revision ID: *N9nnnn4n1nn*
Item Name: Att Tube Assembly

Start Date: 8/15/2016 Start Qty: 1.00 *1*
Required Date: 8/22/2016 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:
Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5-Inspect part completeness to step on W/O	0.00							
1qn	QC	Memo							
Quality Control									

AUG 21 2017

200 * Chemical Conversion Coat per OSI005 4.1 0.00
2nn
HandFinish Memo 0.10
Hand Finishing

① 2017-08-21
MAG 3L

210 QC7-Inspect Chemical Conversion Coat 0.00
21n
QC Memo 0.00
Quality Control

1 2 17.08-21

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Suspected Unapproved		Skid-tube		Cross tube		Water Jet	
NCR No. _____		Use-as-is		Machining		Small Fab		Prod. Eng. Coord.	
Date : _____		Step #:		Thermoforming		Finishing		Rec/Store/Packaging	
				Large Fab		Composite		Supplier	
Description Work Order Deviation		Disposition		MRB (QSI042) Approval					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/ Surge	Positioned Wrong				
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions				
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance				
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect				
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing				
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved				
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing				
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish				
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Mistread				
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence				
Past Expiry Date	Manufacturing Process								
Misidentified	Past Due								
		OTHER :							

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____ Date: _____		Step #: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Skid-tube Machining ☐ Thermoforming Large Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐						MRB (QS1042) Approval					
Description Work Order Deviation				Disposition													
														Completed By			
														Lead hand / Supervisor Approval Verification			
														QC / QA Coordinator Approval			
FAULT CATEGORY																	
Root Cause						Temperature/Cure								Power Loss/Surge		Positioned Wrong	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐						Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐						Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing Finish ☐ Misread ☐ Turning Sequence ☐	
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐																	
OTHER: _____																	

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

149931
D3391-025

Start Date: 8/15/2016
Start Qty: 1.00
Required Date: 8/22/2016
Required Qty: 1.00

Comments:
IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev: C 06-03-28 Update Manuf. Instructions JLM
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
IPP Rev: F 07-11-13 ECN 1056 DD verified by: EC
IPP Rev: G 08-09-10 revH as per dwg DD verified by: EC IPP Rev: H
11.11.14 AS PER REV.1 DD verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	13.0000	1	1			
D4095-047									**				
Wearpad Aft													

Location FP001 Loc Qty 13 Loc Code 13162004

140612 5 21

146026 8

260 Each 14.0000

** 1

D4095-049		Manufactured	No			260	Each	14.0000	1	1			
D4095-049									**				
Wearpad Aft													

Location FP001 Loc Qty 14 Loc Code 13160415

126331 2 21

145975 8

260 Each 257.0000

** 12

MS20601-AD4W4		Purchased	No			260	Each	257.0000	12	12			
MS20601-AD4W4									**				
Rivet													

Location ST307 Loc Qty 257 Loc Code

113064 32

113749 197

28

M138238

12

2017/08/23 AP

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other			
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing Composite				Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier			
NCR No. _____		Suspected Unapproved		Skid-tube Machining Thermoforming Large Fab							
Date : _____		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter		Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes		Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due									

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

149931

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/15/2016

Required Date: 8/22/2016

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W9

Purchased

No

260

Each

165.0000

8

8

MS20601-AD4W9

RIVET

9 2017/08/23 AB

Location

Mczz
19191
(M137148)

Loc Qty

10
10
155

Loc Code

ST307

m134215

260

Each

202.0000

10

10

MS2107515

Purchased

No

MS2107515

Nut Plate

**

12 2017/08/23 AB

Location

GA
m134955
(M137951)

Loc Qty

122
122
80

Loc Code

ST298

m133498
m135297

100

Each

44.0000

1

1

D6014-090

Manufactured

No

D6014-090

ALUMINUM EXTRUSION

**

Location
LG003
134851
139426

Loc Qty

44
14
30

Loc Code

1 16/8/15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date: _____		Step #: _____		QTY Effective: _____		MRB (QS1042) Approval					
Description Work Order Deviation				Disposition							
						Completed By					
						Lead hand / Supervisor Approval Verification					
						QC / QA Coordinator Approval					
Root Cause						FAULT CATEGORY					
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing Finish ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Misread ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Turning Sequence ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐			
Past Expiry Date ☐		Manufacturing Process ☐									
Misidentified ☐		Past Due ☐		OTHER: _____							

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

149931
D3391-025

Start Date: 8/15/2016
Start Qty: 1.00
Required Date: 8/22/2016
Required Qty: 1.00

D3670-4-200
D3670-4-200
Bushing

Manufactured No

230 Each 102.0000 4 4

**

17-08-21
Dy

Location

Loc Qty

Loc Code

FG

10

87709

10

138819

92

143536

3

148414

43

270

Each

34.0000

1

1

D2646
D2646
Aft Cap

Manufactured No

**

101 12/02/81

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

127924

30

136885

4

141214

25

270

Each

768.0000

2

2

D3672-1
D3672-1
Washer, Phenolic

Manufactured No

**

101 12/02/81

Location

Loc Qty

Loc Code

FG

10

85222

10

112218

450

134785

446

147077

308

308

Monday, August 15, 2016 7:25:43 AM

Shop Packet Print

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other	
NCR No. _____										MRB (QS1042) Approval	
Date : _____		Step #:		QTY Effective :		MRB (QS1042) Approval					
Description Work Order Deviation				Disposition							
Root Cause				FAULT CATEGORY							
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong	
Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions	
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing	
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved	
Internal Transport		Poor Information		Crushing		Countersink		Off-set		Drawing	
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish	
LOA		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread	
Substation		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence	
Past Expiry Date		Manufacturing Process									
Misidentified		Past Due		OTHER :							

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

Parent Item: D3391-025

Parent Item Name: Air Tube Assembly

149931
D3391-025

Start Date: 8/15/2015
Start Qty: 1.00
Required Date: 8/22/2016
Required Qty: 1.00

ALS4-1032-130 AEL54-1032-130 Purchased

No

260

Each

1,381.000

8

8

ALS4-1032-130
Rivnut

**

88 12/10/21/31

Location

Loc Qty

Loc Code

FP001

M133077

479

122

M134502

357

ST556

902

M134502

902

M137820

x8

270

Each

437.0000

4

4

**

ALS4-1032-225 AEL58-1032-225 Purchased
ALS4-1032-225
Rivnut

100 12/10/21/30

Location

Loc Qty

Loc Code

FP001

M133772

429

15

M134975

414

st555

8

M128454

8

M135998

x1



DQA: _____ Date: _____

DART
AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐				Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval									
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor Approval Verification											
										QC / QA Coordinator Approval					

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
		OTHER :									

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

149931
D3391-025

Start Date: 8/15/2016
Start Qty: 1.00
Required Date: 8/22/2016
Required Qty: 1.00

AN3C4A
AN3C4A
Bolt
Purchased No 270 Each 1,472.000 6 6
**
all valves 130

Location	Loc Qty	Loc Code	
FG	20		
122814	20		
FP001	1352	M1379623	
M133440	7		
M134396	41		
M134509	6		
M134606	29		
M134676	44		
M134762	106		
M134861	13		
M135058	1032		
M135127	22		
M135297	52		
ST350	100		
M132317	3		
M134134	18		
M134396	79		

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other	
NCR No.		Suspected Unapproved		QTY Effective :		MRB (QSI042) Approval					
Date :		Step #:		Disposition							
Description Work Order Deviation				Completed By							
				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							

Root Cause				FAULT CATEGORY															
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong														
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions														
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance														
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect														
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing														
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved														
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing														
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish														
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread														
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence														
Past Expiry Date	Manufacturing Process	OTHER :																	
Misidentified	Past Due																		

Picklist Print

Monday, August 15, 2016 7:25:43 AM

Work Order ID: 149931

Parent Item: D3391-025

Parent Item Name: Air Tube Assembly

149931
D3391-025

Start Date: 8/15/2016
Start Qty: 1.00
Required Date: 8/22/2016
Required Qty: 1.00

AN3C5A
AN3C5A
Bolt
Purchased No 270 Each 1,193.000 4 4

20 12/02/30

Location	Loc Qty	Loc Code
RG	5	
122800	5	14137963
FP001	15	
M134502	15	
OVER002	900	
M134955	300	
M135297	600	
ST350	273	
M1333234	272	
M134676	270	
270	Each	4,764.000
		10 10

20 12/02/30

NAS1149C0332R	Purchased	No
NAS1149C0332R		
WASHER		
		**
Location	Loc Qty	Loc Code
FP001	626	
m135046	626	14138237
GA	141	
m1333284	141	
ST260a	1000	
m135408	1000	
ST266	2997	
m134736	997	
m135274	2000	

X10

DQA: Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: _____

Work Order update only ☐

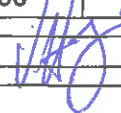


Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						MRB (QS1042) Approval													
Part No. _____		Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other													
NCR No. _____																							
Date : _____		Step #:		QTY Effective :																			
Description Work Order Deviation				Disposition																			
Root Cause				FAULT CATEGORY																			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified				No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due				Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter OTHER : _____				Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes				Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center				Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence			

DART AEROSPACE LTD		Work Order:	149931
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		force	
3.500	+/-0.010	3.500	✓		vernier	
Ø3.200	+/-0.010	3.199				
Ø3.750	+/-0.010	3.749				
30° x 0.060 chamfer	+/-0.010	30° x 0.060				
88.93	+/-0.030	88.93			tape	

Measured by:		Date:	16/8/17
Audited by:		Date:	

HAAS Section						
1.526	+0.000/-0.030	1.520	✓			
7.500	+/-0.010	7.499	✓			
27.750	+/-0.010	27.749	✓			
31.750	+/-0.010	31.749	✓			
35.250	+/-0.010	35.249	✓			
3.300	+/-0.010	3.297	✓			
0.200	+/-0.010	.201	✓			
3.520	+/-0.010	3.522	✓			
0.687	+0.010/-0.000	.691	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

Measured by:	JP	Date:	16-10-23
Audited by:		Date:	17-09-11

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐	
NCR No. _____		Suspected Unapproved ☐		QTY Effective : _____							
Date : _____		Step #:		MRB (QS1042) Approval							
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____							
Misidentified ☐		Past Due ☐									

10

[illegible]

RETURN TO

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11.0

DATA

而

15

151

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DQA: _____ Date: _____

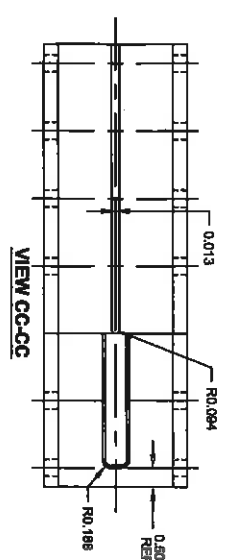
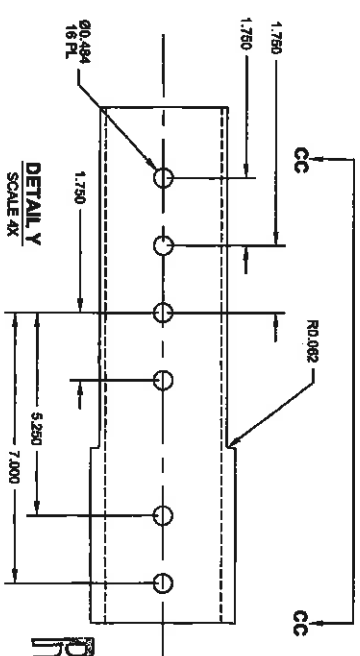
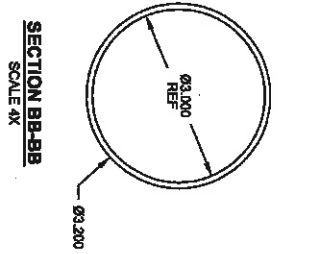
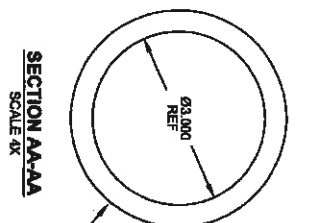
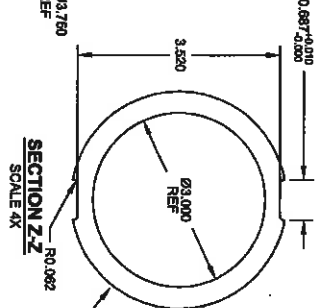
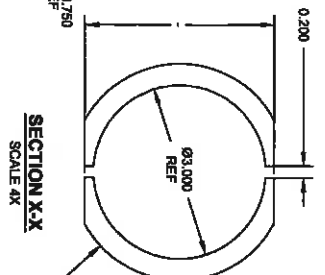
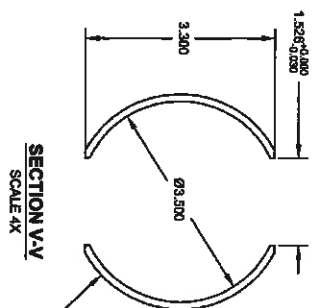
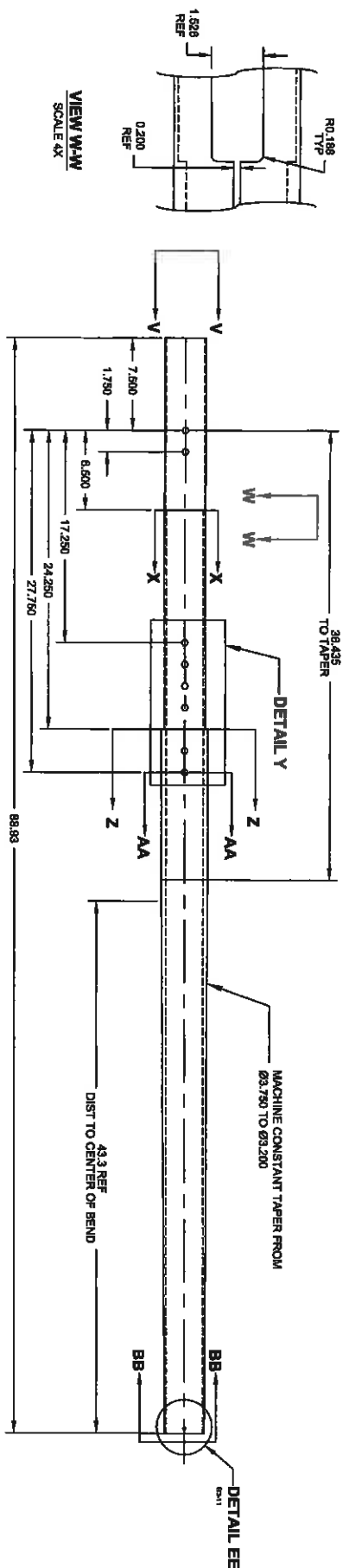
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

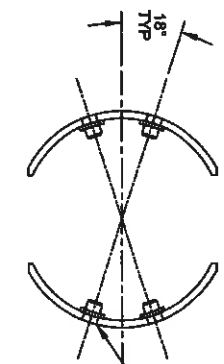


Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS											
Part No. _____		Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Machining Thermoforming Large Fab		Cross tube Small Fab Finishing Composite		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier		Engineering Quality Other					
NCR No. _____															
Date : _____		Step #:		QTY Effective :		MRB (QS1042) Approval									
Description Work Order Deviation				Disposition											
Root Cause				FAULT CATEGORY											
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified				Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter				Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes				Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center			
No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due															
OTHER : _____															



DART AEROSPACE USA, INC					
EUGENE, OR					
DESIGN	PH	DRAWING NO.		REV. J	
DRAWN	M/L	D3391		SHEET 10 OF 11	
CHECKED	CP			SCALE	
MFG APPR.	<i>DEC</i>	TITLE		NTS	
APPROVED	<i>[Signature]</i>	412 FLOAT SKIDTUBE			
DE APPR.	<i>[Signature]</i>				
DATE	16.01.14				

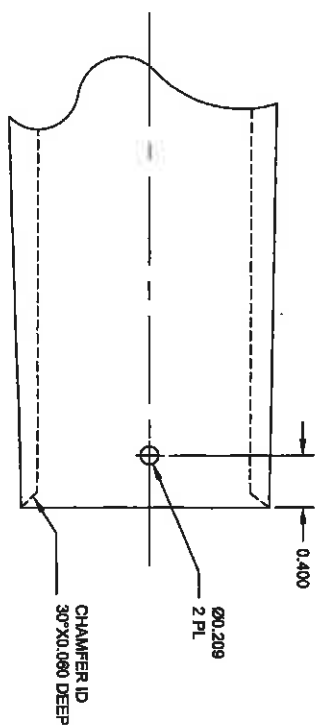
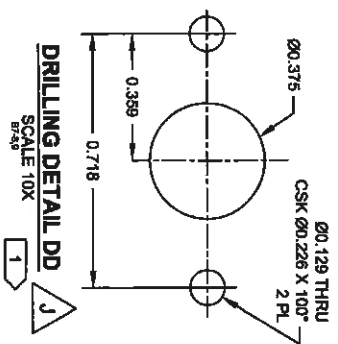
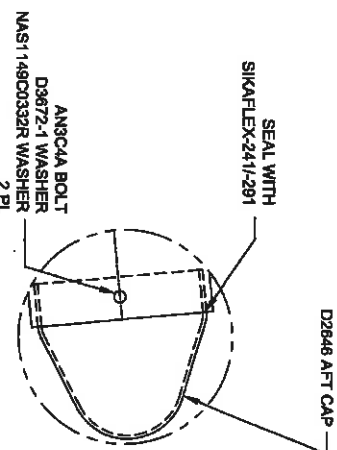
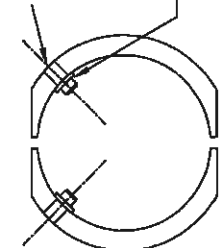
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DRILL Ø0.301
CORE Ø0.516 X 0.040 DEEP
INSTALL AL54-428-165 INSERT
4 PL.

MS21078L5 NUT-PLATE
REF

USE D78217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO Ø0.375



NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	ML	EUGENE, OR
CHECKED	CP	DRAWING NO.
MFG. APPR.	12	REV. J
APPROVED	12	SHEET 11 OF 11
DE APPR.	12	TITLE
DATE	16.01.14	AFT TUBE ASSEMBLY
		SCALE
		NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		Date : _____ Step #: _____ QTY Effective : _____		MRB (QS1042) Approval ☐	
Description Work Order Deviation				Disposition					
Completed By				Lead hand / Supervisor Approval Verification					
QC / QA Coordinator Approval				QC / QA Coordinator Approval					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37596**

Purchase Order Date 8/29/2017
PO Print Date 8/29/2017

Page Number 1 of 3

Order From : VC-ATE001
ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 242 5633	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:		FOB	Destination-Collect
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	164638	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00
Line Total:							\$110.00
2	164788	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00
Line Total:							\$110.00
3	149931	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00

PO Instructions: PRIMER AND PAINT SUPPLIED BY DART
Note:

8/29/2017

8/28-30

